

Order ID 102250
-13 12:42:12 PM

Handwritten: -2, ~~SPLIT~~

Handwritten: Split 1
102250

U/R

D: D412-630-034
n ID: *U/R OK 9/13/6/4*
ame: Heli Access Step RH Folding
ate: 6/14/13
ed Date: 6/14/13
ace:

Accept
Start Qty: *1*
Req'd Qty: *1*

N900040100
Cust Item ID:
Customer:

Setup Start *NS1*
Stop *NS2*

als: Process Plan: *MLJ* Date: *13-05-28* Tooling:
QC: Date: SPC (Y/N):

Run Start *NR1*
Stop *NR2*

ce ID/ Center ID	Operation Description	Set Up/ Run Hours
---------------------	--------------------------	----------------------

Nbr	Revision Nbr	
412-630	Rev M	

Handwritten: 10
DOCUMENT CONTROL
Memo
Photocopy bluefile & create labels per PPP D412-630-034 CHG003

Handwritten: 10
Small Fab
Memo
Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: *1117817*
COAT exposed HARDWARE WITH LPS PROCYON
A/R LPS PROCYON BATCH: *1122900*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Handwritten: DAS 6 9-89
13/12/11
Handwritten: 1x

Handwritten: 4x

Handwritten: 13/10/11

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Item ID: D412-630-034

Revision ID: U/R

Item Name: Heli Access Step RH Folding

Start Date: 6/14/13 Start Qty: 1.00

Required Date: 6/14/13 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 0.00 9-89 13/10/11				4			
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				4			D4 13-10-01
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 DAS 6 0.00 9-89 13/10/11				5			

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Item ID: D412-630-034

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Item Name: Heli Access Step RH Folding

Stop *NS2*

Start Date: 6/14/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging	0.00	DAS 6 9-89	DAS 31 9-89					
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: _____								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13/01/11



MCS 13-10-11

MF
13-10-11

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Work Order ID: 102250

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 Nut		Purchased	No			110	Each	51.0000	2	2	8		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST342		51							
				124858		1							
				m125709		50				125709	8		
AN3C21A BOLT		Purchased	No			110	Each	33.0000	2	2	8		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		33							
				124858		33				125952			
AN44C7A Eyebolt		Purchased	No			130	Each	18.0000	1	1	4		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		12							
				M125730		12				1x			
				ST361		6							
				125389		6							
AN4C10A Bolt		Purchased	No			130	Each	24.0000	1	1	10		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		24				2x126102			
				120840		5							
				123900		19				123900			

DAS
6
9-89

DAS
31
9-89

DAS
6
9-89

DAS
31
9-89

13-10-02

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Work Order ID: 102250

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

AN4C15A
Bolt

Purchased

No

130 Each 166.0000

2

2

②

Location

Loc Qty

Loc Code

FG 10
120360 10
ST357 56
120360 6
124858 50
ST513 100
125388 100

130 Each 1,546.0000

1

+

①

Location

Loc Qty

Loc Code

FG 14
103344 4
121657 10
ST337A 1000
m125709 1000
ST355 82
122800 12
123900 20
124419 50
ST513 200
125388 200
ST516 250
124215 250

130 Each 48.0000

2

126180

②

330

13-10-02

Location

Loc Qty

Loc Code

ST337 48
124858 48

DAS
8
9-89

AN4C6A
Bolt

Purchased

No

130 Each 1,546.0000

1

+

①

Location

Loc Qty

Loc Code

FG 14
103344 4
121657 10
ST337A 1000
m125709 1000
ST355 82
122800 12
123900 20
124419 50
ST513 200
125388 200
ST516 250
124215 250

130 Each 48.0000

2

126180

②

330

13-10-02

Location

Loc Qty

Loc Code

ST337 48
124858 48

AN5C15A
Bolt

Purchased

No

130 Each 48.0000

2

126180

②

330

13-10-02

Location

Loc Qty

Loc Code

ST337 48
124858 48

DAS
8
9-89

DAS
31
9-89

DAS
31
9-89

DAS
31
9-89

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Work Order ID: 102250

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

AN8C16
Bolt Purchased No

110 Each 18.0000

2 125958

D4
33
88

Location

Loc Qty

Loc Code

ST341

18

124826

18

D2012-107
Clevis Manufactured No

110 Each 23.0000

1 X4

D4
33
88

Location

Loc Qty

Loc Code

ST003

4

96997

4

WA004

19

98258

9

99578

10

* D2803-042
Bracket Assembly Manufactured No

110 Each 10.0000

1 101563

D4
33
88

Location

Loc Qty

Loc Code

ST149

10

101734

5

99021

1

99767

4

impossible
101734

98-6
36
DAS

* D2804-042
Bracket Assembly Manufactured No

110 Each 14.0000

1 X4

D4
33
88

Location

Loc Qty

Loc Code

GA

4

101563

4

ST150

10

100833

5

83941

1

90532

2

98572

2

101563

4

98-6
36
DAS

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Work Order ID: 102250

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

D2806-1
Bushing

Manufactured No

130 Each 43.0000

Location

Loc Qty

Loc Code

ST018

43

100379

30

97134

1

99694

12

130 Each 67.0000

Location

Loc Qty

Loc Code

ST018

67

101081

17

101244

26

99819

24

110 Each 34.0000

Location

Loc Qty

Loc Code

FG

4

89606

4

GA

7

92881

5

94607

2

ST018

23

101613

11

99688

12

130 Each 8.0000

Location

Loc Qty

Loc Code

ST253

8

101855

1

99656

7

D2807-041
Door prop

Manufactured No

D2810-5
Strut

Manufactured No

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
31
9-89

DAS
31
9-89

DAS
31
9-89

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Work Order ID: 102250
Parent Item: D412-630-034
Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

D2813 Washer Manufactured No

110 Each 22.0000

2 101605 8

33 89

Location	Loc Qty	Loc Code
ST018	22	
69386	1	
99681	21	

D3395-1 Bushing Manufactured No

110 Each 103.0000

4 101249

33 89

Location	Loc Qty	Loc Code
ST042	103	
100544	39	
101249	63	
97308	1	

D3396-1 Spacer Manufactured No

130 Each 28.0000

2 101784 2 101249 4x 105459

33 89

DAS 31 2.89

Location	Loc Qty	Loc Code
ST042	28	
94771	8	
96921	20	

D3562-042 Step Assembly, RH Manufactured No
MS21043-3 Nut Purchased No

110 Each 0.0000
110 Each 1,892.0000

B 105452 4x 101784 2 101249 4x 105459

+4 10/10/11

126741 6 33 89

13-10-02

Location	Loc Qty	Loc Code
FG	80	
103691	80	
GA	106	
123899	106	
ST315	1706	
123899	196	
124555	1510	

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Work Order ID: 102250
 Parent Item: D412-630-034
 Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13 Required Date: 6/14/13
 Start Qty: 1.00 Required Qty: 1.00

MS21043-4 Purchased No

130 Each 1,534.0000

4 125807 4 33 89

Location	Loc Qty	Loc Code
FG	36	
104603	36	
GA	6	
121652	6	
ST315	1492	
121162	25	
123021	3	
123525	29	
123900	2	
125654	1433	

DAS
6
9-89

DAS
31
9-89

MS21043-5 Purchased No

130 Each 473.0000

3 814 3 33 89

Location	Loc Qty	Loc Code
FG	20	
101418	20	
GA	96	
116548	96	
ST315	357	
119307	25	
119537	1	
121283	131	
121584	200	

DAS
6
9-89

DAS
31
9-89

MS24665-302 Purchased No

110 Each 65.0000

2 2 8 33 89 13-10-02

Location	Loc Qty	Loc Code
GA	65	
120521	65	

121283 120521

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Work Order ID: 102250

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 1.00

Required Qty: 1.00

MS24693-C280

Purchased

No

Screw

110

Each

77.0000

2

28

335

Location

Loc Qty

Loc Code

ST301

77

124704

77

124704

24

335

13-10-02

NAS1515H3

Purchased

No

Washer

110

Each

373.0000

6

Location

Loc Qty

Loc Code

FG

4

123301

10

GA

3

124859

3

ST297

356

123301

13

125654

343

125654

28

335

NAS1515H4

Purchased

No

Washer

130

Each

543.0000

7

Location

Loc Qty

Loc Code

ST297

543

120770

50

121649

10

125574

483

125574

28

335

13-10-02

NAS1515H5

Purchased

No

Washer

130

Each

538.0000

7

Location

Loc Qty

Loc Code

FG

40

103691

40

ST297

498

121652

2

125574

496

125574

335

DAS
6
9-89

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Work Order ID: 102250

Parent Item: D412-630-034

Start Date: 6/14/13

Required Date: 6/14/13

Parent Item Name: Heli Access Step RH Folding

Start Qty: 1.00

Required Qty: 1.00

NAS1515H5L Purchased No

110

Each

524.0000

4

A 16 D4 335 89

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST297

484

124859

22

125621

462

125621

NAS1515H8

Purchased

No

110

Each

146.0000

4

A 16 D4 335 89

Washer

Location

Loc Qty

Loc Code

ST297

146

124858

146

124858

13-10-0

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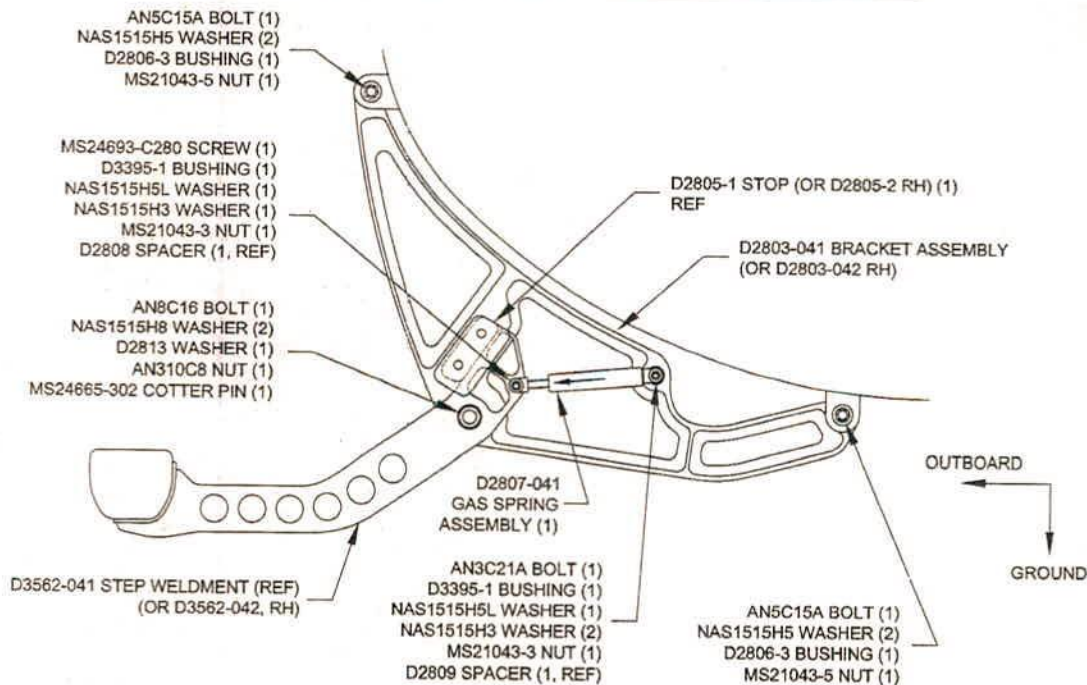
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

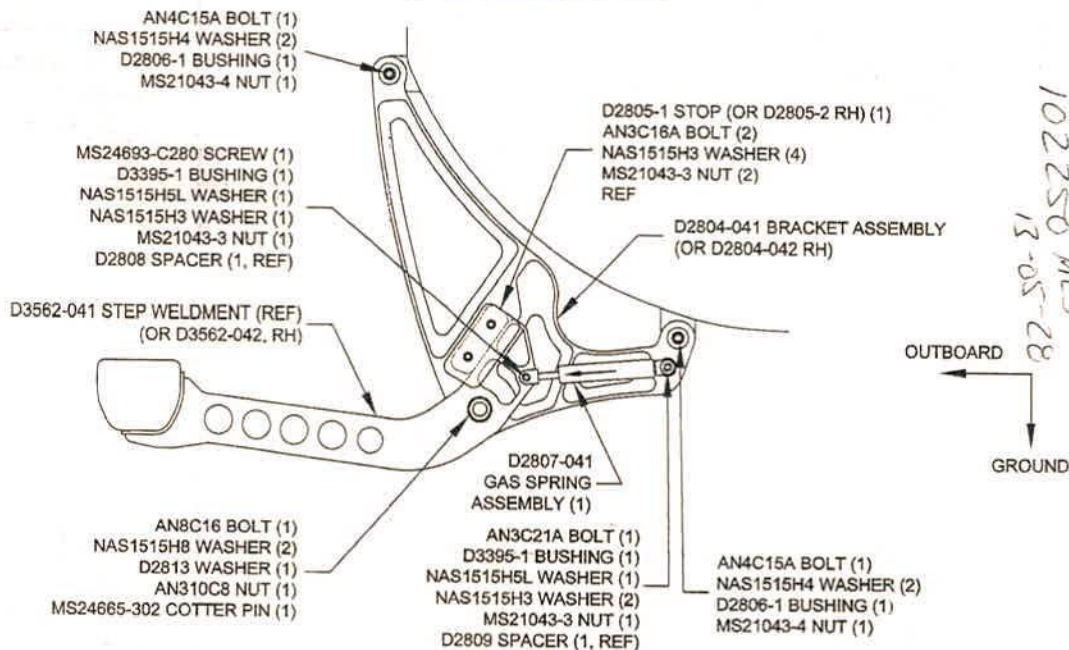


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: **M**
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)